

**Work Order ID 69145**

Tuesday, May 03, 2011 11:35:09 AM



Page 1

Item ID: D350-636-014

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 17053

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3492

C

IIN-D350-636

H

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-014 CHG 006

5/11/11

\* JGR BG 11-9-20

69145

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-4 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8- Open up holes for SECTION A-W-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB 4/08/29

W/O:		WORK ORDER CHANGES					
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: M117884 BE 11/08/29

12-Grind welds flush as per Dwg D2750 BL 11/08/31

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

S 11/08/31

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/08/31

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00				1			DL
	Hand Finishing								11/08/31
	Memo								
150	QC3- Inspect Part Finish	0.00							
	QC	0.00				1	8		BE11/08/31
	Quality Control								
	Memo								

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes section BE-BE 0.500" (4 per side) as per dwg D2750

2-Open holes section BC-BC 0.3125" (4 per side)

3-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

4-Chamfer holes of section BE-BE, BC-BC, AB and ground handling (welding instructions on sheet 11)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291batch: M118393exp. date: 12/04/05

7- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 11)

A/R ☐☐☐ Aluminum Rodbatch: M118336

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

*Handwritten:* 11/09/01

*Handwritten:* BE 11/09/13

*Handwritten:* B 11/09/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

S u l o r 1/3

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S u l o r 1/3



Quality Control

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

N O M - 11/04/15

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 5/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 1:00

OVEN TEMPERATURE: 320 °F

FINISH TIME: 1:30

0.00

210

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

Inspect for foreign object per QSI 024

0.00

1X M-11/09/15

1 BR 11-9-16.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 69145**

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Item Name: Skidtube RH

Start Date: 5/3/2011 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-assemble o'ring as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 1103483-Assemble tube hardware as per dwg D2750 sikaflex batch: 118393

4-Inspect For Foreign Objects

5-Spray inside of tube with "LPS-3" batch: N/A

6-Install blade fitting D3488-041, wearshoe

SIKA FLEX 241

BATCH: 118393  
EXP DATE: 12-5

7-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 1103488-Coat all exposed fasteners with "LPS Procyon" batch: 1145961 PR 11-9-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tuesday, May 03, 2011 11:35:09 AM

[illegible]

**Stop**



**Abstract**

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

1. The first step is to identify the key components of the system. This includes understanding the hardware, software, and data involved.

**Stop**

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Abstract**

**Insp.  
Stamp**

0.00



QC

## Memo

0.00

## Quality Control

0.00



### Packaging

## Memo

0.00

## Packaging

0.00



OC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-014

Rev I

11/9/22

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/9/27

MF 11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

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Page 1

Work Order ID: 69145

Parent Item: D350-636-014

Parent Item Name: Skidtube RH



Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 02.09.25 Rearranged procedure steps KJ  
 IPP Rev:I 05.12.08 Rearranged procedure steps EC  
 IPP Rev:J 06.03.30 Per rev. D EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-09-23 revF as per dwg DD verified by:ec IPP Rev:N  
 10.06.22 revise seq110 DD verf:EC IPP Rev:O 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT		Manufactured	No			110	Each	23.0000	1	1			
Extrusion Bent													

Location	Loc Qty	Loc Code
LG 72153	23	
66874	1	
66875	8	
68137	10	
68138	4	

D2739		Manufactured	No			160	Each	14.0000	1	1			
350 I Beam													

Location	Loc Qty	Loc Code
LG 70823	14	
67785	2	
68285	6	
68286	6	

D2743		Manufactured	No			160	Each	187.0000	8	8			
Crossbolt Spacer													

Location	Loc Qty	Loc Code
LG001	187	
67766	123	
68251	64	

BE 11/09/13  
 871839 \*8

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

160

Each

37.0000

1

1



Cap



BE 11/08/29  
B 70881

Location

Loc Qty

Loc Code

LG002

37

62715

8

65086

29

D3490-1

Manufactured No

160

Each

93.0000

4

4



Cross Bolt Spacer



BE 11/09/13  
B 69823

Location

Loc Qty

Loc Code

LG

91

67773

31

68105

60

LG001

2

62450

2

D3490-5

Manufactured No

160

Each

74.0000

4

4



Cross Bolt Spacer



BE 11/09/13

Location

Loc Qty

Loc Code

LG001

74

46490

18

59230

56

ALS4-1032-225

Purchased

No

230

Each

1,069.000

38

38



Insert



BE 11-9-19

Location

Loc Qty

Loc Code

FP-B

28

110768

28

ST282

1041

110768

1041

38.

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A Purchased No 230 Each 1,332.000 34 34  
  
 Bolt

*BL 11-9-19.*

Location	Loc Qty	Loc Code
FP-A	7	
115835	7	
ST350	1325	
115422	49	
116419	376	
116549	100	
117343 ✓	500	
117508	300	

*34.*

AN3C6A Purchased No 230 Each 300.0000 4 4  
  
 BOLT

*BL 11-9-19.*

Location	Loc Qty	Loc Code
FP-A	1	
111982	1	
ST351	299	
111982	2	
116419	47	
116549	50	
116704	100	
117514	100	

*117872*

*4.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:35:23 AM

Page 4

Work Order ID: 69145

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

86.0000

4

4



BOLT



BR 11-9-19.

Location

Loc Qty

Loc Code

FG

118332

2

103964

2

ST344

84

116874

4

117407

80

4.

AN8C35A

Purchased

No

230

Each

70.0000

1

1



BOLT



BR 11-9-19.

Location

Loc Qty

Loc Code

FP

40

117511 ✓

40

FP-A

30

115960

7

116874

23

1

AN960C10L

NAS1149C0332 / R

Purchased

No

230

Each

0.0000

38

38



washer

118354



38.

BR 11-9-19.

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER



NAS 1149C0832R. 114915.

1

BR 11-9-19.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:35:23 AM

Page 5

Work Order ID: 69145

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230 Each

214.0000 8 8



Bushing



BL 11-9-19.

## Location

## Loc Qty

## Loc Code

FP-A 69529  
67764  
68248

214  
13  
201

8.

D3488-042

Manufactured No

230 Each

12.0000 1 1



Blade Fitting Assembly, RH



BL 11-9-19.

## Location

## Loc Qty

## Loc Code

FP008 68109  
62003  
65099

12  
4  
8

1

D3492-1

Manufactured No

230 Each

0.0000 8 8



Plug

70185.



8.

BL 11-9-19.

D3492-5

Manufactured No

230 Each

0.0000 8 8



Plug

69533.



8.

BL 11-9-19.

D3535-25

Manufactured No

230 Each

18.0000 1 1



Wearshoe



BL 11-9-19.

## Location

## Loc Qty

## Loc Code

FP018 69743  
62233  
65167  
68353

18  
1  
6  
11

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:35:23 AM

Page 6

Work Order ID: 69145

Parent Item: D350-636-014



Parent Item Name: Skidtube RH

Start Date: 5/3/2011



Required Date: 5/17/2011

Start Qty: 1.00



Required Qty: 1.00

D3536-25      Manufactured      No      230      Each      37.0000      1      1  
  BR 11-9-19.  
 Gasket



Location	Loc Qty	Loc Code
FP012 <b>70780</b>	37	
65903	11	
68351	26	

D3537-1      Manufactured      No      230      Each      39.0000      3      3  
  BR 11-9-19.  
 Wearpad

Location	Loc Qty	Loc Code
FP017 <b>70607</b>	39	
63313	2	
66135	33	
66935	4	

D3631-1      Manufactured      No      230      Each      500.0000      8      8  
  BR 11-9-19.  
 Washer

Location	Loc Qty	Loc Code
ST072	500	
68062 ✓	500	

D3672-1      Manufactured      No      230      Each      1,379.000      8      8  
  BR 11-9-19  
 Phenolic Washer

Location	Loc Qty	Loc Code
FP-A	29	
52505	29	
ST074	1350	
64177	850	
66821 X	500	

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Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 03, 2011 11:35:24 AM

Page 7

Work Order ID: 69145

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3791-1  
  
 Wearplate

Manufactured No

230 Each

8.0000

1 1



*BL 11-9-19.*

Location

Loc Qty

Loc Code

FP017 *69282*  
 62239

8  
 8

*1*

D3793-1  
  
 Wearshoe

Manufactured No

230 Each

15.0000

1 1



*BL 11-9-19.*

Location

Loc Qty

Loc Code

FP018 *70781*  
 61710  
 64445

15  
 1  
 14

*1*

D3793-3  
  
 Wearshoe

Manufactured No

230 Each

23.0000

1 1



*BL 11-9-19.*

Location

Loc Qty

Loc Code

FP018 *70813*  
 68356  
 FP019  
 64447

13  
 13  
 10  
 10

*1*

D3794-1  
  
 Gasket

Manufactured No

230 Each

33.0000

1 1



*BL 11-9-19.*

Location

Loc Qty

Loc Code

FP010 *70779*  
 39279  
 39421  
 61704  
 68355

33  
 1  
 1  
 5  
 26

*1*

Tuesday, May 03, 2011 11:35:24 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:35:24 AM

Page 8

Work Order ID: 69145

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230 Each

35.0000

1

1



Gasket



BL 11-9-12.

Location

Loc Qty

Loc Code

FP010 70812

26

1

68357

26

FP018

9

39422

1

61712

8

MS21043-6

Purchased

No

230

Each

527.0000

4

4



NUT

BL 11-9-12.

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

44

112314 ✓

44

4.

ST301

463

112314

463

MS21083C8

Purchased

No

230

Each

91.0000

1

1



NUT

BL 11-9-12.

Location

Loc Qty

Loc Code

FP-B 118077

1

1

115884

1

ST303

90

115884

0

117291

40

117423

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:35:24 AM

Page 9

Work Order ID: 69145

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

Purchased

No

230

Each

216.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP002

216

106099-1

111

114220

105

8.

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP

80

117460

80

FP-A

186

110915

139

115589

47

8.

AN8C21A

Purchased

No

250

Each

78.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST345

78

116381

28

117562

50

8.

AN960JD816

Purchased

No

250

Each

45.0000

2

2



1/2" washer, Alum

Location

Loc Qty

Loc Code

FP-A

45

106043

45

8.

Tuesday, May 03, 2011 11:35:25 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 11:35:25 AM

Page 10

Work Order ID: 69145

Parent Item: D350-636-014

Parent Item Name: Skidtube RH

Start Date: 5/3/2011

Required Date: 5/17/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250 Each

45.0000

1 1



Blade, 350 Skidtube



SP 11-09-20  
B70667-1X

Location

Loc Qty

Loc Code

ST466

45

61341

7

63589

38

D3493-1

Manufactured No

250 Each

33.0000

2 2



Washer



SP 11-09-20

Location

Loc Qty

Loc Code

ST062

33

66975

33

MS21083C8

Purchased No

250 Each

91.0000

2 2



NUT



SP 11-09-20

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

90

115884

0

117291

40

117423

50

m118354

2X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

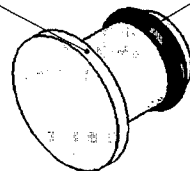
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
1			1				NAS1611-007	O-RING
							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING



#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69145-  
R11-053

UNDER REVIEW

OK ASS 08.11.12

DEO ATTACHED

RELEASED  
5.12.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3492	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLUG	2:1
DATE	07.10.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

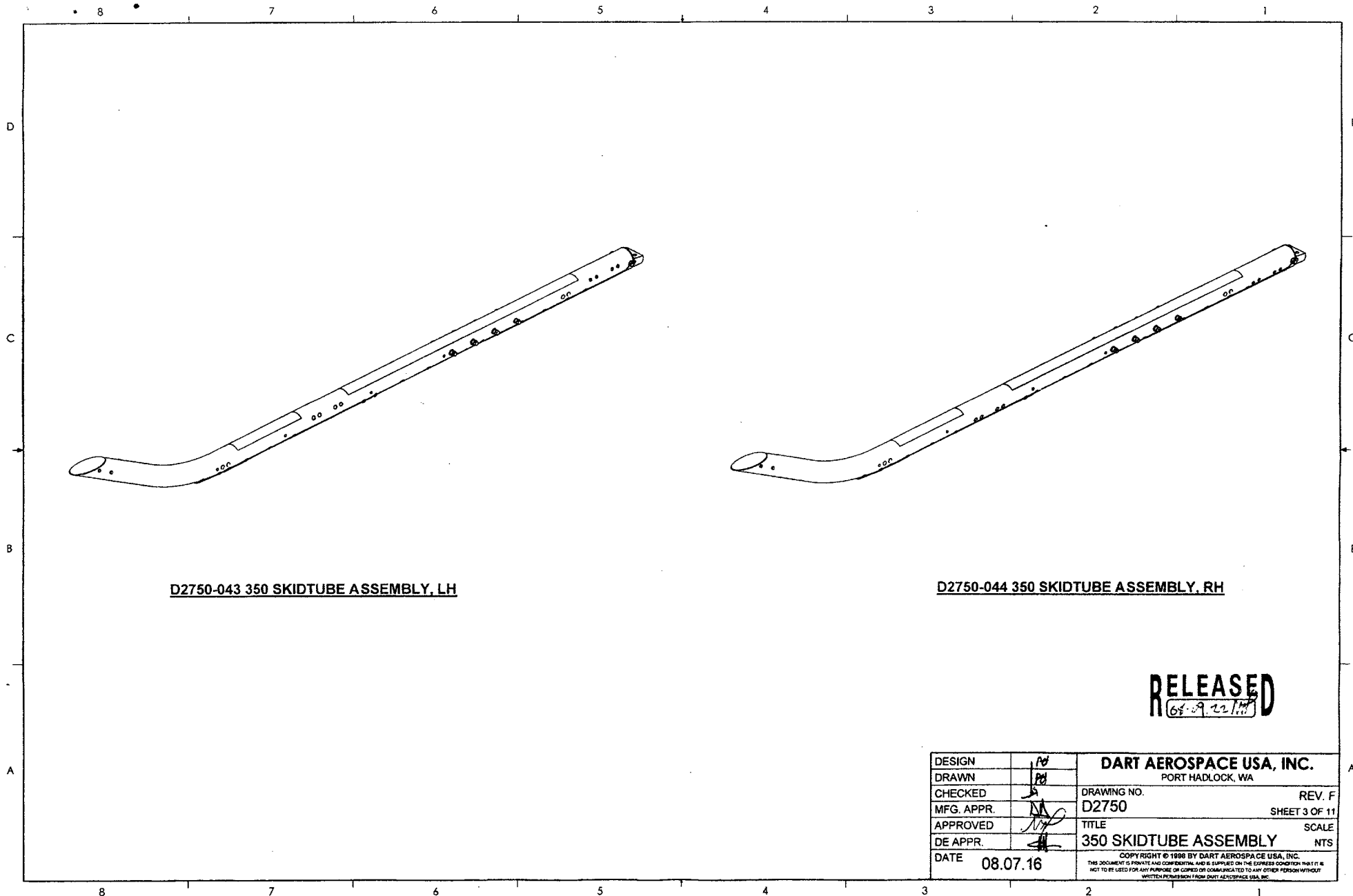
## GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION A-JAJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION A-PAP EXCEPT HORIZONTAL

RELEASED  
68-07-22-14

F	INCORPORATE DSI 9413; QTY (3) D3637-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/8157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	88.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	RAH	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.	AK	D2750	SHEET 1 OF 1
APPROVED	AK	TITLE	SCALE
DE APPR.	AK	350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

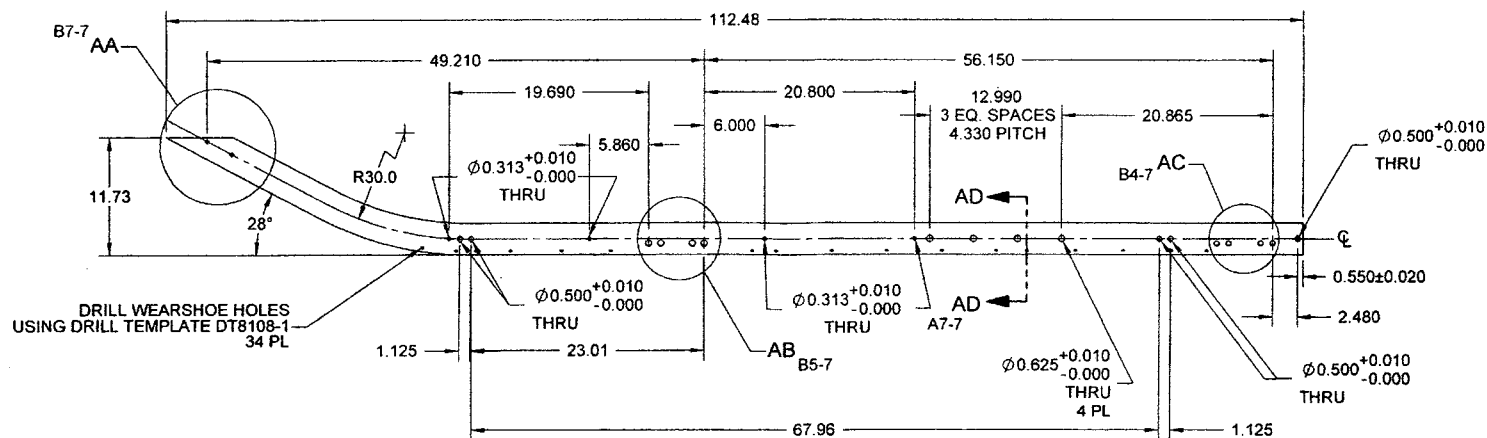


D2750-043 350 SKIDTUBE ASSEMBLY, LH

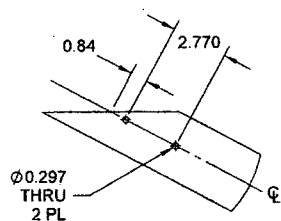
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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64-9-22/100

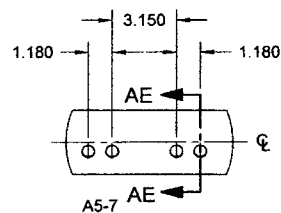
DESIGN		<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA DRAWING NO. <b>D2750</b> TITLE <b>350 SKIDTUBE ASSEMBLY</b> DATE <b>08.07.16</b>	REV. F
DRAWN			SHEET 3 OF 11
CHECKED			SCALE
MFG. APPR.			NTS
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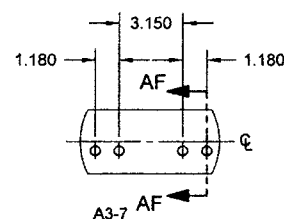
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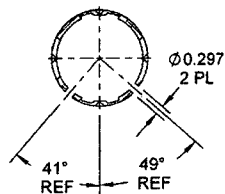
**DETAIL AA**  
SCALE 2X



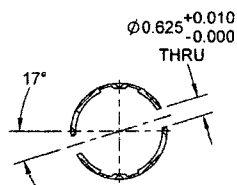
**DETAIL AB**  
SCALE 2X



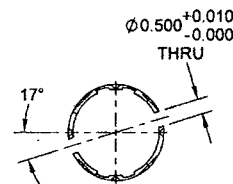
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



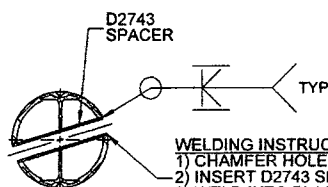
**SECTION AF-AF**  
SCALE 3X, 4 PL

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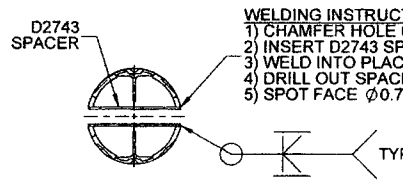
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DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	<b>08.07.16</b>	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

A1-11  
BA

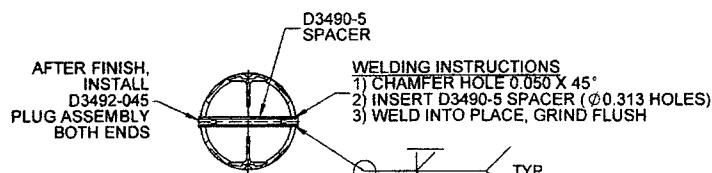
BLACK ANTI-SKID

REFER TO  
SECTION BE-BEAN6C44A BOLT  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL  
(INSTALL NUT ON THIS SIDE)BOND D2739 WEB INTO D2750-4 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.D2750-4  
SKIDTUBEAFTER FINISH,  
ALS4-1032-225 INSERT  
34 PLREFER TO  
SECTION BC-BCD3794-1  
GASKETD3793-1  
WEARSHOEAN3C5A BOLT  
AN960C10L WASHER  
34 PLD3537-1  
WEARPADD3791-1  
WEARPLATED3536-25  
GASKETD3535-25  
WEARSHOE1.78 TO  
D2739 WEBD3488-042  
BLADE FITTINGAN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-042 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON THIS SIDE)**D2750-044 350 SKIDTUBE ASSEMBLY, RH****SECTION BB-BB**  
SCALE 3X, 4 PL

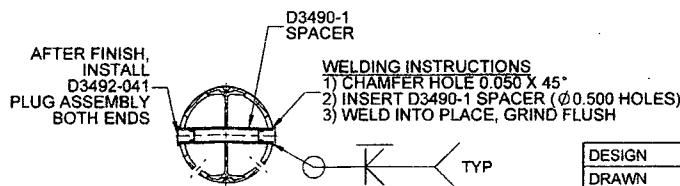
D6-11

**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

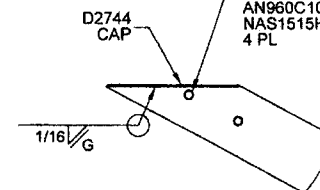
D4-11

**SECTION BC-BC**  
SCALE 3X, 4 PL

D5-11, C6-11

**SECTION BE-BE**  
SCALE 3X, 4 PL

D4-11, D7-11

**DETAIL BA**  
SCALE 2X

D8-11

DESIGN	
DRAWN	
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MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WADRAWING NO.  
**D2750**  
TITLE  
**350 SKIDTUBE ASSEMBLY**

REV. F

SHEET 11 OF 11

SCALE

NTS

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NO. 265

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 714270  
Part number: J 350 636 015  
Description: 350  
Welding Process: Tig ☒ Mig ☐  
Base material: Aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Sal Luy Date of Test Coupon 11.09.06  
Welder Barclay Elliott Date of Test Coupon 11.09.06

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries